Wai	rk (	)rder	· ID	663	27
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Quality Control



Page 1.

Insp.

Stamp

Monday, February 14, 2011 10:09:14 AM D3413-1 Item ID: Accept Setup Start Revision ID: Stop Item Name: Ring Start Date: 2/14/2011 **Start Oty: 12.00 Cust Item ID: Required Date: 2/25/2011** Req'd Oty: 12.00 **Customer:** Reference: Run Start Date: h - OQ - f Tooling: Process Plan: Mf Approvals: Date: Stop Date: SPC (Y/N): QC: Date: Sequence ID/ Operation Reject Reject Set Up/ Tool ID Tool # Plan Accept Work Center ID Description **Qty** Qty Number Run Hours Code Draw Nbr **Revision Nbr** D3413 Rev A 100 0.00 FLOW WATER JET 0.00 Waterjet Memo FLOW CNC Waterjet 1-Cut as per Dwg D3413 304 , 255x 4,00 Dwg Rev: Prog Rev: 2-Deburr if necessary 110 QC2- Inspect parts off machine FAI/FAIB 0.00 0.00 Memo Quality Control 120 QC8- Inspect parts - second check

Memo

	. copaco .								
W/O:			WO	RK ORDER CHANG	SES				
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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							!		
Part No	:	PAR #:	Fault Categ	ory:	_ NCR: Yes	No <b>DQ</b>	<b>A</b> :	Date: _	
	Res	solution:	Disposition	<b>:</b>	QA: N/C CI	osed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NCF	R)	· ·		
DATE	STEP	Description of NC		<del> </del>	tion B	Verific	ation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section	on C	Chief Eng	QC Inspector
							· - · · · -		

#### Work Order ID 66387

Monday, February 14, 2011 10:09:14 AM



Page 2

Item ID:

D3413-1

Accept

Setup Start

Stop

Stop



**Revision ID:** 

**Item Name: Start Date:** 

Ring

**Start Qty: 12.00** 2/14/2011

Req'd Qty: 12.00

**Cust Item ID: Customer:** 

Reference:

Approvals:

Process Plan: \_\_\_\_\_ Date: \_\_\_\_ Tooling:

Date:

Tool # Plan

Code

Start Run



Required Date: 2/25/2011

Date:

SPC (Y/N):

Date:

**Tool ID** 

Qty

Accept

Reject Qty

Reject Number Stamp

Insp.

Sequence ID/ **Work Center ID** 

130

Small Fab

Small Fab

Operation Description

Small Fab

Set Up/ **Run Hours** 

0.00

Memo

0.00

1- Deburr and drill hole if required as per dwg D3413 & QSI018 4.1.

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Eulos/03

145

SprayPaint

Spray Painting

Spray Painting per QS1005 4.2

Memo

0.00

Prime Delfleet Blue : B 115967
Paint Delfleet Blue : B 115509
Clear Delfeet : B 115949

0.00

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W/O:			WORK ORDER CHANGES						
DATE	STEP	PF	ROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No	:	PAR #:	Fault Category:	NCR: Ye	s No DQ	A:	Date: _	J	
	Resolutio	on:	Disposition:	QA: N/C	Closed:		Date:		

	WORK ORDER NON-CONFORMANCE (NCR)									
	Description of NC		Corrective Action Section B	Varification	Approval	Approval				
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector			
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	STEP	STEP Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Section A Initial Action Description	STEP Description of NC Section A Initial Action Description Sign &	STEP Description of NC Section A Corrective Action Section B Verification Section C Section C	STEP Description of NC Section A Initial Action Description Sign & Verification Section C Chief Eng			

### Work Order ID 66387

Monday, February 14, 2011 10:09:14 AM



Page 3

Item ID:

D3413-1

Accept

Setup Start

Stop

**Revision ID:** 

**Item Name:** 

Ring

Required Date: 2/25/2011

2/14/2011

QC:

**Start Qty: 12.00** 

Req'd Qty: 12.00



**Cust Item ID:** 

**Customer:** 

Reference:

**Start Date:** 

Approvals:

Process Plan:

Date: \_\_\_\_\_

Date:\_\_\_\_\_

Tooling:

SPC (Y/N):

Date: Date:

Run

Stop

Start

Sequence ID/ **Work Center ID** 

160

QC

Operation Description

QC3-Inspect Part Finish

Memo

Set Up/ Run Hours

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

BT 11-03-09

Reject Insp. Number

Stamp

Quality Control

Packaging

Packaging

Identify as per dwg & Stock Location: 420

0.00 0.00

180

170

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

Memo

0.00

Dart Aeros	pace Ltd
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W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Categ	ory:	NCR: Yes	No <b>D</b> Q	A:	Date: _	·
	R	esolution:	Disposition	:	_ QA: N/C Cld	sed: _		Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR	)			
DATE	STEP	Description of NC		on B Sign &		cation	Approval	Approval	
DAIL	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	Date	Sec	tion C	Chief Eng	QC Inspector
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### **Picklist Print**

Monday, February 14, 2011 10:09:11 AM

Work Order ID: 66387

D3413-1 Parent Item:

Parent Item Name: Ring



Start Date: 2/14/2011

Required Date: 2/25/2011

Page 1

**Start Oty: 12.00** 

Required Oty: 12.00

Comments:

IPP Rev:A□05.09.13□New issue□KJ/JLM

IPP Rev:B Now on Wateriet 07-05-28 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch		rimary ocation	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250X4.000	15118 11881 51111 6811 181211 618	Purchased	No			100	f	17.0000	0.25	3.157895	3.	6	
										183	11-3-1		

304 BAR .250 x 4.00

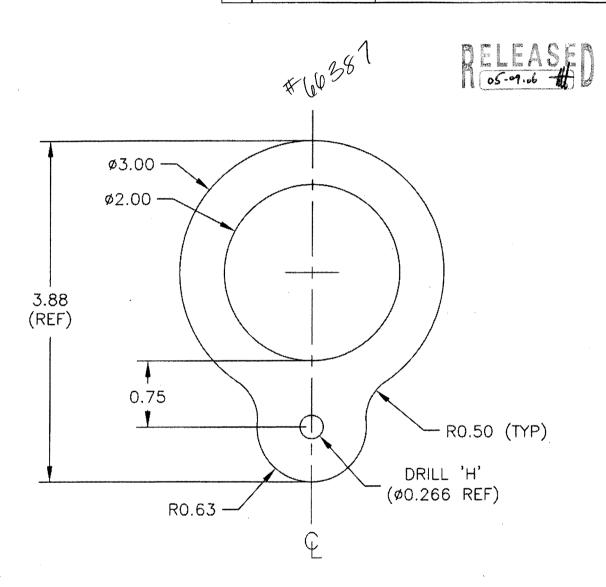
Location	Loc Qty	Loc Code		$\sim$
MAT	17			1141
115953	5		115953	ー(ソ
116808	12			$\sim$

D	ar	t	A	er	0	S	p	a	C	е	Ľ	t	b	

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W/O:			W	ORK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CHA	NGE	В	/	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	gory:	_ NCR: \	es N	o <b>DQ</b> .	<b>A</b> :	_ Date: _	<u> </u>
	R	esolution:	Dispositio	n:	QA: N/	C Clos	ed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORM	ANCE (N	ICR)				
DATE	CTED	Description of NC		tion B		Verific	cation	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		gn & Date	Secti	on C	Chief Eng	QC Inspector
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DESIGN	CP.	DRAWN BY	DART	AEROSPACE PORT HADLOCK, V	
CHECK	ED AN	APPROVED A	DRAWING NO.	<del></del>	REV. A
	卅	l off	D3413		SHEET 1 OF 1
DATE			TITLE		SCALE
05.0	3.16		RING		1:1
Α		05.03.16	NEW ISSU	JE	



www.serimon

# D3413-1 RING

- 1) MATERIAL: AISI 304/316 SS PLATE, 0.250 THICK (REF DART SPEC. M304S3GA)
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) DEBURR ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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W/O:			W	ORK ORDER CHANG	GES					
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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										<u> </u>
Part No	:	PAR #:	Fault Ca	tegory:	NCI	R: Yes	No <b>DQ</b>	A:	Date:	
Resolution:			Disposit	Disposition: QA					Date: _	
NCR:			WORK OR	DER NON-CONFORM	IANCE	(NCF	1)			
DATE	STEP	Description of NC Section A	Initial	Corrective Action Sec Action Description	ction B	tion B Sign &		cation ion C	Approval Chief Eng	Approval QC Inspector
		Section A	Chief Eng	Chief Eng		Date	Seci		Ciller Ling	QC IIIspector
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DART AEROSPACE LTD	Work Order:	(2006)
Description: Ring	Part Number:	D3413-1
Inspection Dwg: D3413 Rev: A		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.88	+/-0.030	13.881	¥-		U	
Ø2.00	+0.012/-0.001	7.000	×		V	
0.75	+/-0.030	744	<b>1</b> 55		V	
Ø0.266	+0.006/-0.001	200	>		V	
0.250	+/-0.010	2)C.	ک		V	
	-					
			·-			
						-

Measured by:	B	Audited by:	Prototype Approval:	N/A
Date:	11-3-1	Date: 11/03/83	Date:	N/A

Rev	Date	Change	Revised by Approved
Α	07.09.06	New Issue	KJ/JLM X
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W/O:			WO	RK ORDER CHANGES	3				
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		·							
L									
Part No	:	PAR #:	Fault Categ	jory:	NCR: Yes	No <b>DQ</b>	A:	Date: _	
	R	esolution:						Date: _	
NCR:			WORK ORDE	ER NON-CONFORMAN	ICE (NCF	<b>(</b> )			
D.4.T.E	STEP Description of NC Section A	Description of NC	Corrective Action Section B			Verification		Approval App	Approval
DATE		Initial Chief Eng	Action Description  Chief Eng	Sign 8 Date		tion C	Chief Eng	QC Inspector	